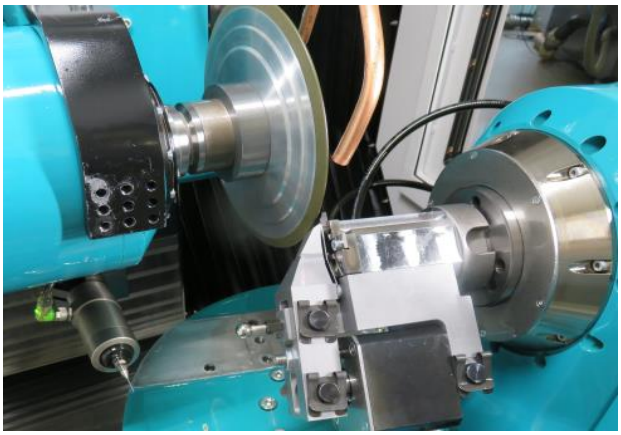
Application Data Sheet

SCHNEEBERGER

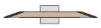
Insert R4.34 Z2 IDØ15.875

A08-200

The radiusprofile is ground with standard profilingprocess. Chipbreaker is executed in oscillationmode generating the bottom radius of 4 mm. The below mentioned cycletime is per side.



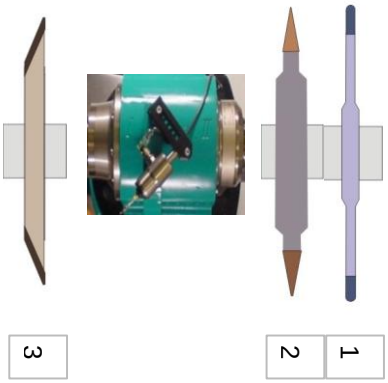
1. Cycletime for Production

Workpiece: 15.875x15.875x4.76 Material CERMET					
Operations	Probe	Pregrinding	Finishing	Polishing	Chipbreaker
Feed [mm/Min]	2000	8	8	40	2400
Power [kW]		3	2	2	2
Cutting speed [m/s]		20	20	20	20
Used wheels		1	2	2	 3
Grinding time [s]	11	125	107	26	258
Total cycle time		8 Min 47			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø200 D64 R1
2	14EE1 Ø200 D46V20º
3	1V1 Ø180 D54



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGS
Control: Fanuc 31iB 5
Accessories: RPC

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

Responsible engineer: OP, 13.7.16

www.schneeberger.ch
J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY FOR TOOLING